




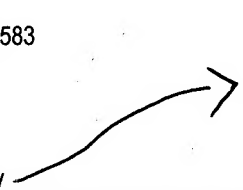








Date: Friday, 21/07/2006 12:04:08 PM  
User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LATCH BRACKET
Job Number	: 28018		
Estimate Number	: 10994		
P.O. Number	: N/A	Part Number	: D2583
This Issue	: 21/07/2006 S.O. No. : N/A	Drawing Number	: D2583 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 28018	Material	: N/A
Written By	: _____	Due Date	: 12/08/2006
Checked & Approved By	: _____	Qty:	100 Um: Each
Comment	Est: C 00.11.01 Removed P/O for Powder Coat- in house processDM Est: D 06.07.21 Waterjet EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M5052H32S040	5052-H32 .040 Sheet	
			
Comment: Qty.: 0.1227 sf(s)/Unit Total : 12.2745 sf(s) Material: 5052-H32 (QQ-A-250/8) 0.040" thick (M5052H32S040) Batch: <del>M17835 (58)</del> <del>M15982</del> <b>M15982 (52)</b> <b>110</b>			
2.0	WATER JET	FLOW WATER JET	
			
Comment: FLOW WATER JET 1-Cut as per Dwg D2583 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary  <b>SAD 06/08/18 (110) - m.f. 06/08/22 (110)</b> <b>SAD 06:08:14 110</b>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <b>SAD 06:08:15 110</b>			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <b>06-08-20 cant (110)</b>			
5.0	BRAKE NC	NC BRAKE	
			
Comment: NC BRAKE Deburr Form on CNC Brake as per-Dwg D2583 <b>2B 06/08/24 (110)</b>			

Date: Friday, 21/07/2006 12:04:09 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH BRACKET

Job Number: 28018

Part Number: D2583

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD

06:09:02

110

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL

06 09 06

110

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6/9/8

110

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 190

6/9/8

110

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/09/11

110

Job Completion



U 06-09-11

PTO →

Date: Friday, 7/21/2006 7:37:24 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : LATCH BRACKET
<b>Job Number</b> : 28018	
<b>Estimate Number</b> : 10994	
<b>P.O. Number</b> :	<b>Part Number</b> : D2583
<b>This Issue</b> : 7/21/2006 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2583 REV. B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 25326	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 8/12/2006 <b>Qty:</b> 100 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est: C 00.11.01 Removed P/O for Powder Coat- in house processDM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M5052H32S040	5052-H32 .040 Sheet
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**Comment:** Qty.: 0.1227 sf(s)/Unit Total : 12.2745 sf(s)  
 Material: 5052-H32 (QQ-A-250/8) 0.040" thick  
 (M5052H32S040) Batch: \_\_\_\_\_

2.0	SHEAR	SHEAR
-----	-------	-------



**Comment:** SHEAR  
 Cut blank: 4.000" x 2.130"  
 Grain offset 10° along 3.188"

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Machine as per folio D2583

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



**Comment:** NC BRAKE  
 Deburr  
 Form on CNC Brake as per Dwg D2583

P10 →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06-08-28	S.O	ADD QCS to inspect bending. Perm. Change	EC	06-08-28			
	S-1	QCS Inspect work.		06-08-28	110		06-08-28

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: Date: 06/05/11

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Friday, 7/21/2006 7:37:24 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH BRACKET

Job Number: 28018

Part Number: D2583

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



*Handwritten signature and date 06-07-06*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

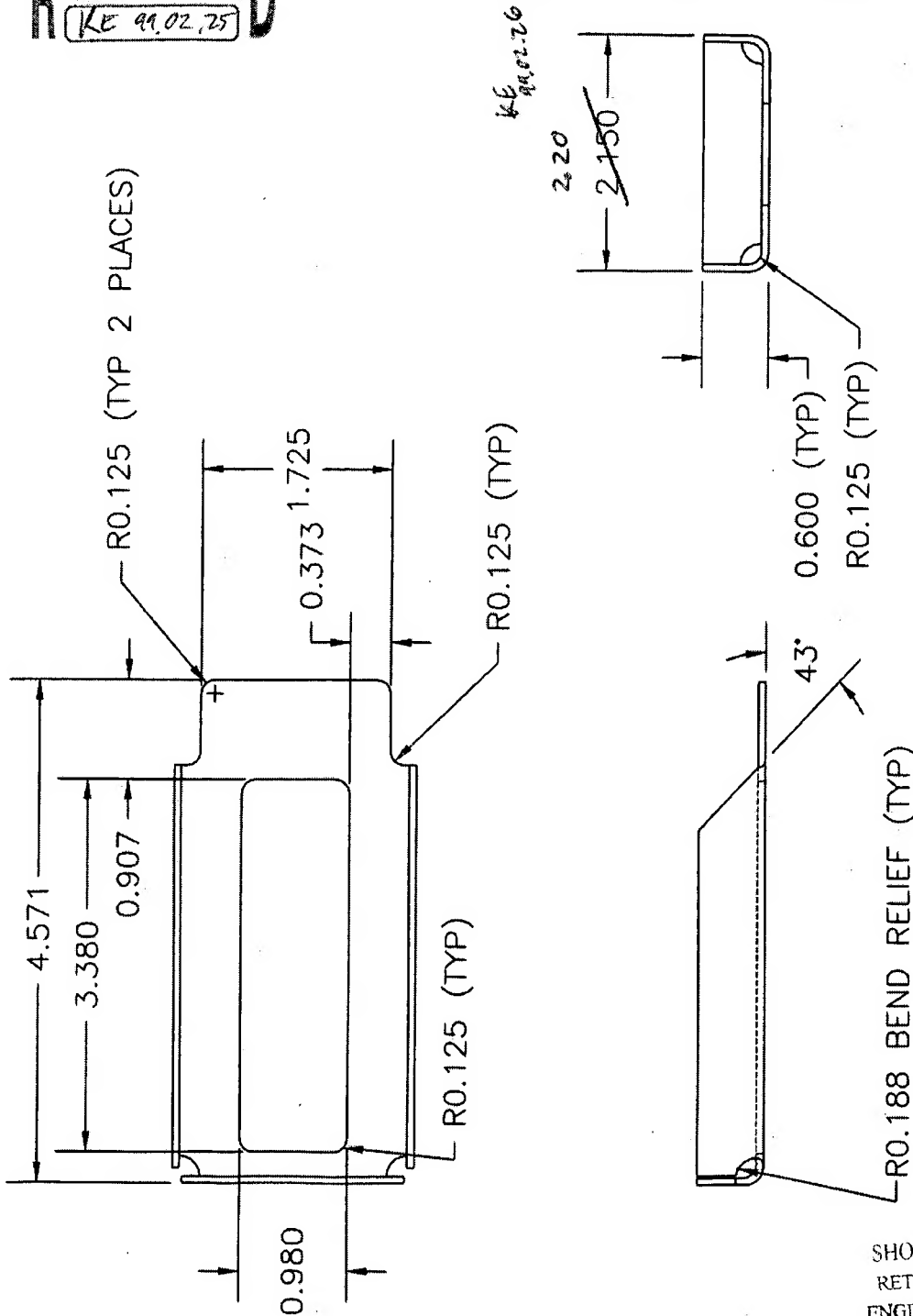
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



**DART**

DESIGN MIKE M.	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED KE	DRAWING NO. D2583	REV. B SHEET 1 OF 1
DATE 99.02.22		TITLE LATCH BRACKET	SCALE 2:3
A	96.07.10	NEW ISSUE	
B	99.02.22	CHANGE OF FINISH (PER TSR A887)	

**RELEASED**  
KE 99.02.25

MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING

UNCONTROLLED COPY

Copyright 1996 by DART AEROSPACE LTD SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 28018